

Date: Friday, 11/04/2008 9:02:17 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW KIT (EC 135)
Job Number : 38555	
Estimate Number : 10536	
P.O. Number :	Part Number : D135692011
This Issue : 11/04/2008 S.O. No. :	Drawing Number : D3049 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 35655	Material :
Written By :	Due Date : 30/04/2008 Qty: 49 Each
Checked & Approved By : JLD 08.4.11	
Comment : Est Rev:C 04.02.17 Blank size changed, Tolerance added Step 3 KJJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D135-692-011 CHG002



JLD 08/04/01 8.4.21

2.0	MUHMWB10	UHMW 1" Black
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**Comment:** Qty.: 5.6280 sf(s)/Unit Total : 28.1400 sf(s)

blank: 16.00" x 23.50" x 1.00" thick (+0.030/-0.000)

per DSK086-9

Material: Black UHMW 1"(MUHMWB10)

Batch: M105863

SD 08/04/29

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1

3-Deburr

SD 08/04/30

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SD 08/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

28 04/04/30

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

7.0 D2182B Rubber Cushion



Comment: Qty.: 0.5000 f(s)/Unit Total: 2.5000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B060(6th) Rubber Cushion 35769

SP

8.0 D2274 Radius Block



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block 37630

SP

9.0 D2519 Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2519 Clamp B34306

26216 7x

SP

10.0 D2529 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer 37210

SP

11.0 AN415A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN4-15A Bolt 107321

8511

SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
8/5/1	7.	4 x 6" inches total 8 feet D2182B060(6") total is 8 feet D2182B060	SCD	8/5/1		08/05/01	P.	

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Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

8 AN960JD416

Washer

Batch

101321

sq

13.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

8 MS21042L4

Nut (or -4)

Batch

106051

sq

14.0

QS100M24S

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description

2 D3049-1(ref)

Bearpaw

Batch

30819

4 QS100M24S

Clamp

106155

1 Paperwork package from Step 2(ref)

8/5/1

sq

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

5 08/05/01 (4)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-692-011

Location:

PPP Rev:

2 8/5/01 (4)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/02

Job Completion



mf 08-05-02

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DART AEROSPACE LTD		Work Order: 38555
Description: Bearpaw		Part Number: D3049-1
Inspection Dwg: D3049	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A Ø0.260	+0.005/-0.000	0.260	/			
B 0.93	+/-0.030	0.928	/			
C 0.40	+0.030/-0.000	0.403	/			
D 2.00	+/-0.030	2.008	/			
E 10.250	+/-0.010	10.250	/			
F 4.540	+/-0.030	4.540	/			
G 5.88	+/-0.030	5.884	/			
H 0.38	+/-0.030	0.380	/			
I 15.50 11.50	+/-0.030	11.50	/			
J 0.07 x 45°	+0.030/-0.010	0.06 x 45°	/			
K 0.44 - 0.47	+/-0.000	0.450	/			
L R0.25	+/-0.030	R0.25	/			
M 0.38	+/-0.010	0.378	/			
N 0.95	+0.030/-0.010	0.951	/			
O 0.69	+/-0.030	0.690	/			
P 0.20	+/-0.030	0.204	/			
Q 23.00	+/-0.030	23.00	/			
R 0.25 x 45°	+/-0.030	0.25 x 45°	/			

Measured by: SD	Audited by: SF	Prototype Approval: N/A
Date: 08/04/29	Date: 08/04/29	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	

Dart Aerospace Ltd

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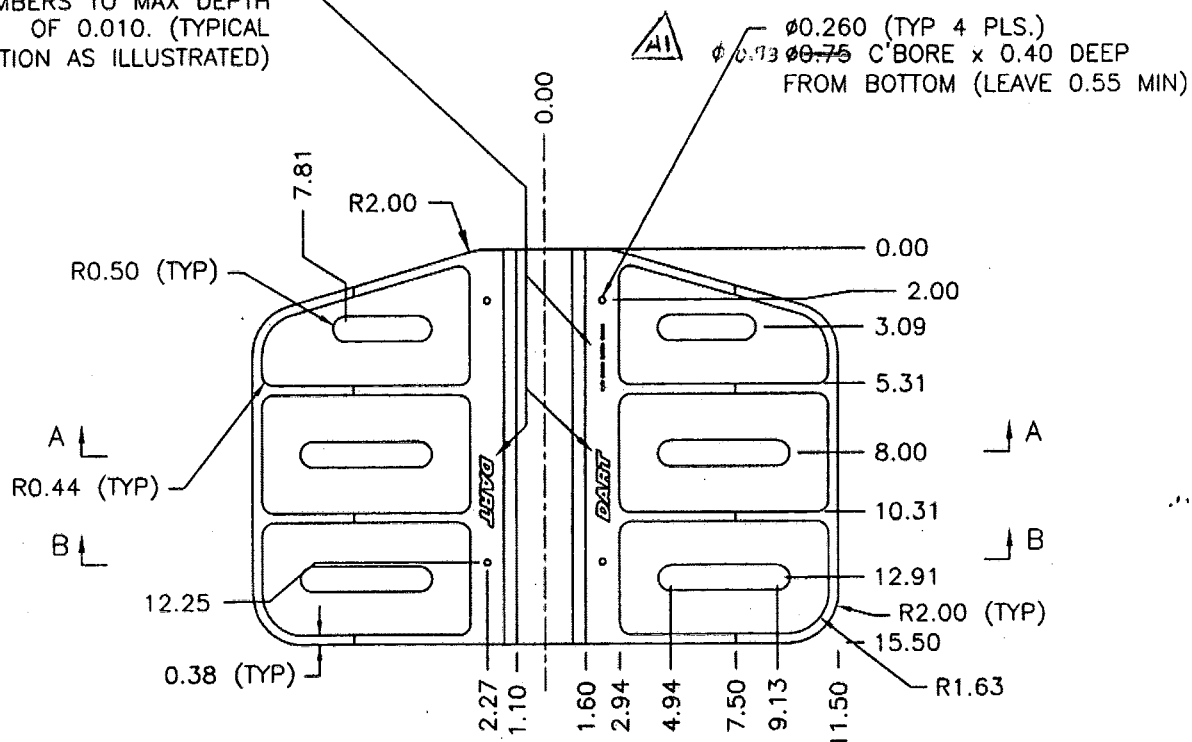
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:1
A	01.10.18	NEW ISSUE	
AI	# RF 03.01.13	$\phi 0.73$ WAS $\phi 0.75$	

RELEASED
01.10.24 #

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 38555

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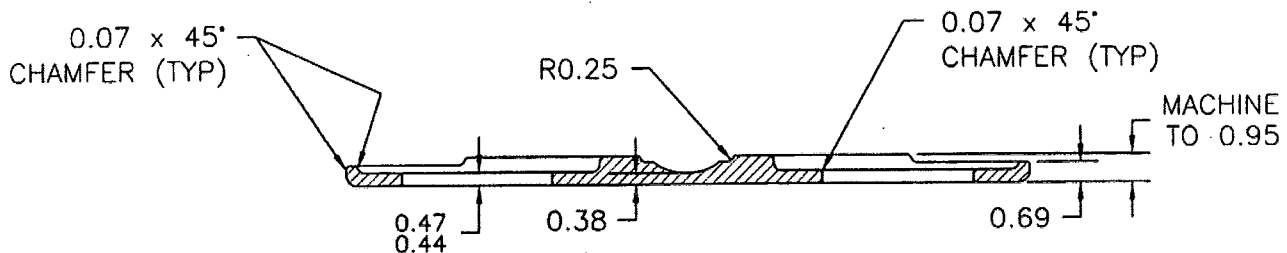
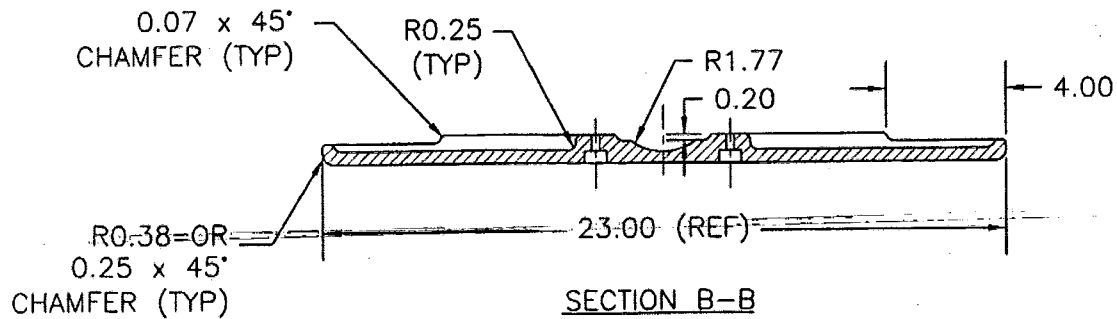
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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 #SECTION A-ASECTION B-B

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